

Date: Wednesday, 1/30/2008 8:02:43 AM  
 User: Kim Johnston

## Process Sheet

|  |                                     |
|--|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : FLOOR PROTECTOR LH   |
| Job Number : 37104                             |                                     |
| Estimate Number : 11226                        |                                     |
| P.O. Number :                                  | Part Number : D32801                |
| This Issue : 1/30/2008 S.O. No. :              | Drawing Number : D3280 REV B        |
| Prsht Rev. : NC                                | Project Number : N/A                |
| First Issue : 1/1 Type : THERMOFORMING         | Drawing Revision : B                |
| Previous Run : 35945                           | Material :                          |
| Written By :                                   | Due Date : 2/8/2008 Qty: 5 Um: Each |
| Checked & Approved By : <u>08 01 30</u>        |                                     |
| Comment : Est Rev: A 04.07.01 New issue KJ/JLM |                                     |
| Est RevB 07.09.12 Thermoform in house DL       |                                     |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |             |
|-----|-----------|-------------|
| 1.0 | F6006 701 | lexan black |
|-----|-----------|-------------|



Comment: Qty.: 4.0000 sf(s)/Unit Total : 20.0000 sf(s)  
 lexan black

|     |                |                              |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

M 106 995  
 BB 08/02/08 X5

|     |               |                       |
|-----|---------------|-----------------------|
| 3.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

BB 08/02/08 X5

Dwg. Rev. CFolio Rev. B

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/02/08 X5

|     |                |                              |
|-----|----------------|------------------------------|
| 5.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/02/11 X1  
 BB 08/02/12 X4

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3280-1 PAR #: N/A Fault Category: Red/Thermoforming NCR: Yes No DQA: 2 Date: 08/02/14  
 QA: N/C Closed: 18 Date: 08/02/14

| NCR: <u>37104</u> |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |                                  |                |                           |                       |                          |
|-------------------|------|------------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE              | STEP | Description of NC<br>Section A     | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|                   |      |                                    | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date |                           |                       |                          |
| 08.02.11          | 3.0  | 16.0 is 15.8<br>5 floor protectors | LE<br>08.02.11              | Acceptable.<br>Due to shrinkage. | BB<br>08/02/13 | 5<br>08/02/11             | LE<br>08.02.11        | 5<br>08/02/11            |
|                   |      |                                    |                             |                                  |                |                           |                       |                          |
|                   |      |                                    |                             |                                  |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 8:02:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR LH

Job Number: 37104

Part Number: D32801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/02/12 (X5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 08/02/13 (X5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 267

AS 08/02/13 (X5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/14 (6)

Job Completion



min, 2008/2/13

(5)

U

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |               |                             |
|---|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>                   |               | <b>Work Order:</b> 37104    |
| <b>Description:</b> R22 Floor Protector, LH |               | <b>Part Number:</b> D3280-1 |
| <b>Inspection Dwg:</b> D3280                | <b>Rev:</b> C | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

| Description   | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than 0.1875"                                  | ✓      |        |                      |          |
| Shape Definition  | ✓      |        |                      |          |
| Texture Retention   | ✓      |        |                      |          |
| Material imperfections such as bumps, cracks, voids, scratching | ✓      |        |                      |          |

Measured by: BB Date: 08/02/11

### TRIMMING SECTION

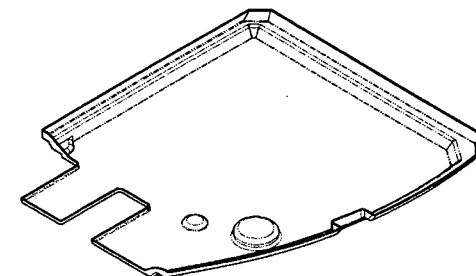
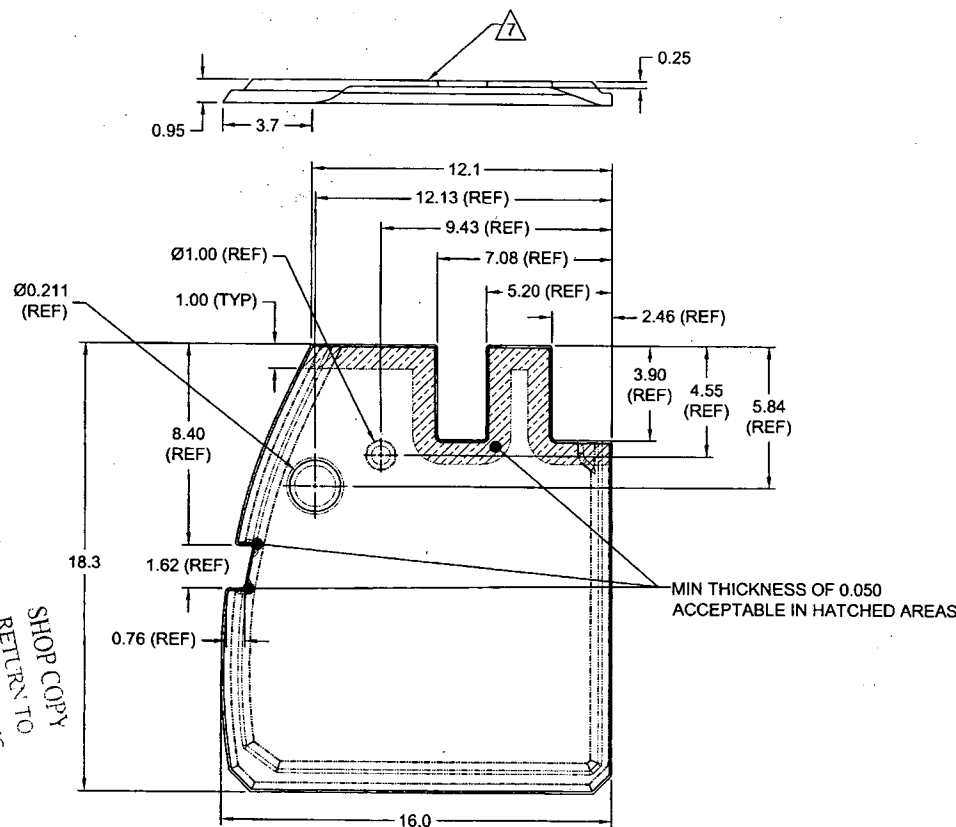
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments            |
|-------------------|-----------|------------------|--------|--------|----------------------|---------------------|
| 18.3              | +/-0.100  | 18.25            | ✓      |        |                      |                     |
| 16.0              | +/-0.100  | 15.8             |        |        |                      | acceptable 08.02.11 |
| 12.1              | +/-0.100  | 12.1             | ✓      |        |                      |                     |
| 0.95              | +/-0.030  | .971             | ✓      |        |                      |                     |
| 0.25              | +/-0.030  | .261             | ✓      |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |
|                   |           |                  |        |        |                      |                     |

Measured by: BB Date: 08/02/11

Audited by: Date: 08/02/11

Prototype Approval: N/A Date: N/A

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 08.01.16 | New Issue | KJ/DL      |          |



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO 2104  
RELEASED  
07.11.06

**D3280-1 FLOOR PROTECTOR**

**D3280-1 NOTES:**

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

| C          | UPDATE DIMS TO MATCH PARTS;<br>COLOUR 701 WAS 700; GENERAL UPDATE | LE | 07.10.12 |
|------------|---|----|----------|
| B          | NOW LEXAN; DIMS AS MANUFACTURED                                   | CP | 05.11.25 |
| A          | NEW ISSUE   | CP | 04.05.03 |
| REV.       | DESCRIPTION   | BY | DATE     |
| DESIGN     | 90  |    |          |
| DRAWN      | CE  |    |          |
| CHECKED    | PA  |    |          |
| MFG. APPR. | PA  |    |          |
| APPROVED   | CH  |    |          |
| DE APPR.   | CH  |    |          |
| DATE       | 07.10.12  |    |          |

|   |                        |
|---|------------------------|
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |                        |
| DRAWING NO.<br>D3280  | REV. C<br>SHEET 1 OF 2 |
| TITLE<br>FLOOR PROTECTOR  | SCALE<br>NTS           |
| COPYRIGHT © 2004 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD |                        |

